



007341

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Canada

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RBW6205G13831-3G

Job Sheet 187636



Part No: RBW6205G13831-3G

Job Qty: 1 ea

Part Name: AW139 Swashplate Box 2



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/10/18

Job Tracking No:

Due Date: 1/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6205G13831-3G REV 2 IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/11/19	0.00	0.00	Start Up Small Fab-4		MCC
110	Small Fab	1 pcs		1/11/19	0.00	1.00	Small Fab-4		MCC DAS
120	QC	1 pcs		1/11/19	0.00	0.00	QC5		38
130	Packaging	1 pcs		1/11/19	0.00	0.00	Packaging3-1		9-89
140	QC21-FG	1 Ea		1/11/19	0.00	0.00	QC21		21 JAN 08 2019

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1600-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBW6205G13831-3G-9 to RBW6205G13831-3G-7 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	90-Start up Operation	5113449
3777T12	Spring Catch	2 Ea (2 ea)	110-Small Fab	5120484
APP-1600-E	Case	1 Ea (1 ea)	110-Small Fab	5077814
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab	5021040
RBW6205G12731-3G	Upper Plate Assembly	1 Ea (1 ea)	110-Small Fab	5134641
RBW6205G13151-3G	Lower Plate	1 Ea (1 ea)	110-Small Fab	5134643
RBW6205G13231-3G	Arm Assembly	3 Ea (3 ea)	110-Small Fab	5134661
RBW6205G13531-3G	Screw Assembly	1 Ea (1 ea)	110-Small Fab	5134663
RBW6205G13831-3G-1	Shelf Backing	1 Ea (1 ea)	110-Small Fab	5077855
RBW6205G13831-3G-11	Dynamometer	1 pcs (1 ea)	110-Small Fab	5079415
RBW6205G13831-3G-3	Shelf	1 Ea (1 ea)	110-Small Fab	5077856
RBW6205G13831-3G-5	Bottom Foam use in case APP-1600-E	1 Ea (1 ea)	110-Small Fab	5077816
RBW6205G13831-3G-7	Lid Foam use in case APP-1600-E	1 Ea (1 ea)	110-Small Fab	5077818
RBW6205G13831-3G-9	Location Placard	1 Ea (1 ea)	110-Small Fab	5138476

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	4	615	0
110-Small Fab	3777T12	2	6	0
	APP-1600-E	1	8	0
	RB41011	1	676	0
	RBW6205G12731-3G	1	3	0

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

RBW6205G13151-3G	1	7	0
RBW6205G13231-3G	3	9	0
RBW6205G13531-3G	1	3	0
RBW6205G13831-3G-1	1	3	0
RBW6205G13831-3G-11	1	5	0
RBW6205G13831-3G-3	1	3	0
RBW6205G13831-3G-5	1	5	0
RBW6205G13831-3G-7	1	5	0
RBW6205G13831-3G-9	1	9	0

Part Specifications

Specifications could not be found.

Plex 12/10/18 3:02 PM Dart.lajeunesse.marie



Container No: S142377



Part: RBW6205G13831-3G

Job No: 187636

Serial No/Batch: S142377

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.

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CANADA

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Email: sales@dartaero.com

www.dartaerospace.com

Date: 01/07/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

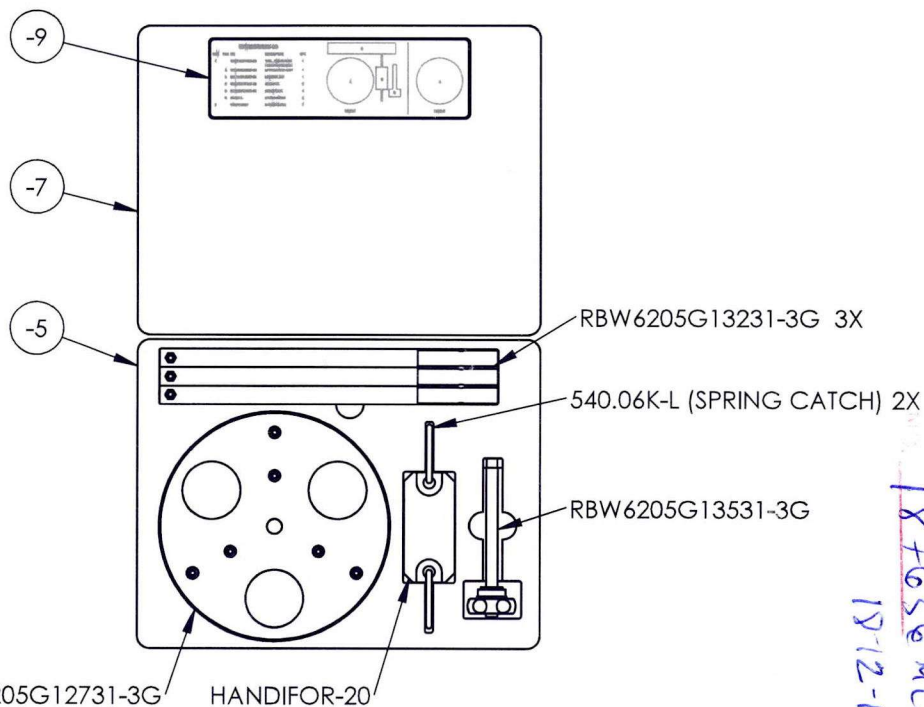
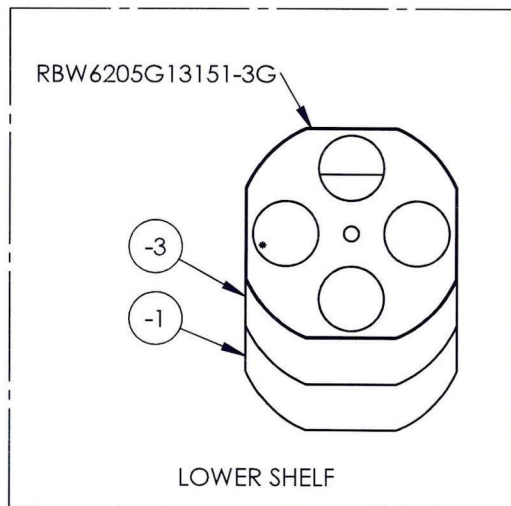
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 & -3 ADDED NOTE. -5 CH'D OVERALL DIMENSIONS TO FIT CASE TIGHTER. -7 CH'D OVERALL DIMENSIONS TO FIT CASE TIGHTER, CH'D CUTOUT TO RECESSED POCKET ADDED CUTOUT ON BOTTOM FOR CASE PIN CLEARANCES AND MATERIAL FROM C200 FLAT TO 1780 FLAT BLACK.	6/29/2011	RJC	RW
2	15-0151	-5 CH'D CUTOUT SIZE AND DEPTH FOR -11 & -13, CH'D DIM WAS ∇ 1.00 IS ∇ 1.60 FOR RBW6205G13231-3G. -7 CHD FOAM WAS 1780 FLAT, BLACK IS Y20 BLACK, CH'D CUTOUT DEPTH FOR PLACARD WAS .063 IS .13. -9 REMOVED TEXT "CONTENT LIST", CH'D DESCRIPTION WAS PLACARD IS LOCATION PLACARD.	7/8/2015	RJC	JAG



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WORK ORDER
187636 MJS
18-12-10

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	UPPER PLATE ASSEMBLY		RBW6205G12731-3G	1
				1	LOWER PLATE		RBW6205G13151-3G	1
				3	ARM ASSEMBLY		RBW6205G13231-3G	1
				1	SCREW ASSEMBLY		RBW6205G13531-3G	1
		B/O	-1	1	SHELF BACKING	COROPLAST	BLACK, 6mm Ø12-7/16 I.R. SPECIALTY	2
		B/O	-3	1	SHELF	Y20 BLACK	Ø12-7/16 X 13/16	3
		B/O	-5	1	BOTTOM FOAM	Y20 BLACK	6-1/8 X 16-3/4 X 21-3/4 I.R. SPECIALTY	4
		B/O	-7	1	LID FOAM	Y20 BLACK	1-3/4 X 16-3/8 X 21-5/16 I.R. SPECIALTY	5
			-9	1	LOCATION PLACARD	PLASTIC		6
		B/O	-11	1	DYNAMOMETER		HANDIFOR-20	1
		B/O	-13	2	SPRING CATCH	S.S.	Ø5/16 CARABINER STYLE (MCMaster-CARR #3777T12)	1
		B/O	-15	1	CASE	PLASTIC, BLACK	8 X 17 X 22 PELICAN #APP-1600-E	N/S
		B/O	-17	1	DART PLACARD	ALUMINUM	#RB41011	N/S

NOTE:
PART OF KIT RBW6205G11231-3G.

DART AEROSPACE	
TITLE AW139 SWASHPLATE KIT	
DWG NO. RBW6205G13831-3G	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CLOUGH APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL AW139
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:10	DATE 1/31/2011
SHEET 1 OF 6	